

UNITED STATES PATENT APPLICATION

FABRIC AND YARN STRUCTURES FOR IMPROVING SIGNAL INTEGRITY
IN FABRIC-BASED ELECTRICAL CIRCUITS

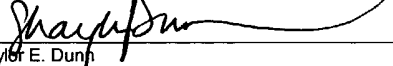
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"Express Mail" mailing number ER238348379US
Date of Deposit June 27, 2003
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Application, Commissioner for Patents, P.O. Box 1450,
Alexandria, VA 22314-1450.


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Description

FABRIC AND YARN STRUCTURES FOR IMPROVING SIGNAL INTEGRITY IN FABRIC-BASED ELECTRICAL CIRCUITS

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Government Interest

This invention was made with U.S. Government support under Grant No.
N39998-98-C3566 awarded by the Department of Defense-Defense Advanced
Research Projects Agency. The U.S. Government has certain rights in the
invention.

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Related Applications

This application claims the benefit of U.S. Provisional Patent Application
Serial No. 60/392,591, filed June 28, 2002 and U.S. Provisional Patent
Application Serial No. 60/447,438, filed February 14, 2003, the disclosures of
15 each of which are incorporated herein by reference in their entirety.

Technical Field

The present invention relates to methods and systems for improving
signal integrity in fabric-based electrical circuits. More particularly, the present
20 invention relates to new fabric and yarn structures and methods for making the

same for solving signal integrity related problems, such as crosstalk, in woven or knitted electrical networks.

Background Art

5 The demand for flexible electrical circuits and circuit boards is increasing in the fields of electronics and computer engineering. Circuit boards have traditionally been rigid structures that use polymeric or epoxy-based material as the dielectric. Copper wiring or interconnect patterns are inscribed on the circuit boards using photolithography or electron beam lithography to obtain a
10 desired wiring pattern. Using rigid circuit boards may not be desirable in all applications as they are inflexible and non-conformable and also due to the fixed volume occupied by such circuit boards.

 In response to the problems associated with conventional rigid circuit boards, flexible circuit boards have been developed. One type of flexible circuit
15 board that has been developed includes textiles-based circuit boards. Textiles-based circuit boards and the corresponding electrical circuits include both conductive fibers and nonconductive fibers. The conductive fibers can be used to interconnect electrical components to form an electrical circuit. A fabric-based electrical network can be incorporated into a garment and worn by the
20 user. Such networks have applications in the fields of medicine, communications, electronics, automobiles, and space exploration. One recent application of fabric-based electrical networks is uniforms for military personnel.

 One problem with fabric-based electrical networks is AC signal crosstalk between adjacent conductors. When conductors in fabric-based electrical

networks are placed parallel and close to each other (though not in direct contact with each other), capacitive and inductive signal crosstalk between neighboring lines can occur. Such crosstalk leads to distortion of signals in neighboring lines that carry electrical signals. In addition, on quiet lines
5 adjacent to a signal-carrying line, crosstalk can cause peaks or troughs due to the rise and fall and electrical signals on the signal-carrying line.

In light of these problems associated with conventional fabric-based electrical networks, there exists a need for improved methods and systems for improving signal integrity in fabric-based electrical circuits.

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Disclosure of the Invention

The present invention includes conductive yarn structures and fabrics containing conductive yarn structures for improving signal integrity in fabric-based electrical circuits. As used herein, the term "conductive yarn" is intended
15 to refer to a group of conductive strands that are twisted together to form a single conductor and exhibiting sufficient flexibility, conformability, resiliency, bending characteristics, and recovery required for fabric-based circuits to be incorporated in wearable garments. Examples of conductive strand material suitable for forming conductive yarns includes copper, steel, gold, aluminum,
20 silver, iron, any of the alloys from the above mentioned materials, and conductive polymers (inherently conductive polymeric materials, such as polypyrrole, polyacetylene, polythiophene and polyaniline, doped conductive polymeric materials, carbon black-doped/impregnated polymeric yarns, metal coated polymeric yarns or fibers and conductive yarns of suitable types). The

term "yarn" is intended to refer to a group of strands (like filaments, fibers, or fine wires) being twisted together to form a single structure. These strands may be continuous or non-continuous along the length of the twisted yarn. A yarn may consist of only one continuous strand (monofilament yarn). In the case of monofilament yarns, the term "yarn" includes filaments and fibers. In the case of monofilament yarns, the term "yarn" includes only very fine wires i.e. with a wire diameter (i.e. monofilament yarn diameter) less than 20 microns. The term "yarn" is not intended to include conventional wires. As indicated above, the term "yarn," as used herein, refers to a structure that exhibits sufficient flexibility, conformability, resiliency, bending characteristics, and recovery required for fabric-based circuits to be incorporated in wearable garments. Conventional wires lack one or more of these characteristics, making them unsuitable for incorporation in a fabric. The individual strands forming the yarn may be very fine wires (twisted to form the yarn) but the diameter of these fine wires should ideally be less than 20 microns to provide sufficient flexibility and conformability of the yarn (twisted strand structure).

One conductive yarn structure of the present invention is a coaxial conductive yarn structure. In a coaxial conductive yarn structure, a first conductive yarn extends in a first direction and has a plurality of conductive strands that are twisted together. An insulating layer surrounds the conductive strands. A second conductive yarn, which also has a plurality of conductive strands being twisted to each other, is wrapped around the insulating layer in a second direction transverse to the first direction. An insulating layer may surround the second conductive strand.

Another conductive yarn structure suitable for reducing crosstalk in a fabric-based electrical network is a twisted pair conductive yarn structure. A twisted pair conductive yarn structure includes a first conductive yarn having a plurality of conductive strands being twisted together (and also having an
5 insulating layer surrounding the twisted strands). An insulating layer surrounds the conductive strands. A second conductive yarn, also having a plurality of strands being twisted together, is twisted together with the first conductive yarn to form a helical structure.

In a woven electrical network including coaxial conductive yarn
10 structures, first and second coaxial conductive yarns are woven (parallel to each other but separated from each other by non-conducting yarns) into a fabric in one direction. The inner conductive yarn of one of the conductive yarn structures may be connected to a signal source. The outer conductive yarn of one or both of these coaxial conductive yarn structures may be connected to
15 ground. When an AC signal is applied to the inner conductor of the first coaxial conductive yarn structure (and/or the inner conductor of the second coaxial conductive yarn structure), the outer conductive yarns of the first and second coaxial conductive yarn structures are grounded and block electromagnetic fields emanating from the inner conductive yarn of the first coaxial conductive
20 yarn structure and thereby reduce crosstalk between the first and second coaxial conductive yarn structures. In a woven electrical network one may also have multiple (more than two) strands of coaxial conductive yarn structures woven into the fabric in one or two of the orthogonal directions (warp and weft directions) of the woven fabric.

As used herein, the term "electrical network" may be used interchangeably with the term "electrical circuit".

Another woven electrical network of the present invention includes first and second twisted pair conductive yarn structures. Each of the first and second twisted pair conductive yarn structures is woven to a fabric in a first direction. One conductor in each of the twisted pair conductive yarn structures is connected to ground. The other conductor in at least one of the twisted pair conductive yarn structures is connected to an AC signal source. When the AC signal is applied to the conductor, the grounded second conductors of the twisted pair conductive yarn structures block electromagnetic fields emanating from the first conductive yarn of the first twisted pair conductor and thereby reduce crosstalk between the first and second twisted pair conductive yarn structures.

According to another aspect, the present invention includes methods and systems for creating conductive thread structures with improved crosstalk resistance while the thread structures are being woven or knitted into a fabric. For example, a coaxial structure may be created by leno weaving conductive threads into a fabric. A similar process may be used to create a twisted pair structure while leno weaving the yarns that make up the twisted pair structure into a fabric. One advantage of creating the structures while the structures are being woven or knitted into a fabric is that the time required to produce such structures is reduced over methods where coaxial or twisted pair structures are formed in advance of making the fabric. Another advantage of forming the structures during the knitting or weaving process is that the weaving can be

altered during the formation of the structures to create floats for selective electrical connection and disconnection.

As used herein, the term "thread" may be used interchangeably with the term "yarn".

5 Accordingly, it is an object of the invention to provide improved methods and systems for reducing crosstalk in fabric-based circuits.

It is another object of the invention to provide improved conductive yarn structures for improving signal integrity in fabric-based electrical circuits.

It is another object of the invention to provide methods for making
10 coaxial and twisted pair structures while the structures are being knitted or woven into a fabric.

Some of the objects of the invention having been stated hereinabove, other objects will become evident as the description proceeds when taken in connection with the accompanying drawings as best described hereinbelow.

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Brief Description of the Drawings

Preferred embodiments of the invention will now be explained with reference to the accompanying drawings of which:

Figure 1 is a perspective view of a coaxial conductive yarn structure for
20 improving signal integrity in fabric-based electrical networks according to an embodiment of the present invention;

Figure 2 is a perspective view of a twisted pair conductive yarn structure for improving signal integrity in a fabric-based electrical network according to an embodiment of the present invention;

Figure 3 is a top view of a fabric-based electrical network including first and second coaxial conductive yarn structures according to an embodiment of the present invention;

Figure 4 is a top view of a fabric-based electrical network including first
5 and second twisted pair conductive yarn structures according to an embodiment of the present invention;

Figure 5 is a top view of a fabric-based signal transmission system in which conductive yarn structures are woven as warp threads into a fabric and twisted around consecutive weft threads to form a spiral pair according to an
10 embodiment of the present invention;

Figure 6 is a top view of a fabric-based signal transmission system in which a bottom doup warp thread goes over consecutive weft threads and crosses adjacent warp threads between two weft threads according to embodiment of the present invention;

15 Figure 7 is a top view of a fabric-based signal transmission system in which insulated conductive yarns are woven in a leno weave to form a twisted pair configuration according to an embodiment of the present invention;

Figure 8 is a top view of a fabric-based signal transmission system in which conductive threads are woven in a leno weave to form twisted pair
20 configurations separated by nonconductive fibers being plain woven into a fabric according to an embodiment of the present invention;

Figure 9 is a top view of a fabric-based signal transmission system in which one thread of a conductive warp thread twisted pair is connected to an

AC signal source and the other thread is connected to ground according to an embodiment of the present invention;

Figure 10 is a top view of a fabric-based signal transmission system in which insulated conductive threads are woven in a leno weave to form twisted pair like structures and wherein the threads include floats and/or woven portions to facilitate electrical connection and disconnection or electrical device attachment;

Figure 11 is a top view of a fabric-based signal transmission system illustrating a crossover point between a leno woven twisted pair structure in the warp direction and a woven or floating twisted pair structure in the weft direction according to an embodiment of the present invention;

Figures 12 is a top view of a fabric-based signal transmission system in which conductive threads are leno woven into a fabric to form a coaxial structure according to an embodiment of the present invention;

Figure 13 is a top view of a fabric-based signal transmission system in which conductive threads are leno woven into a fabric to form a coaxial structure and in which the threads include floating portions or woven portions to facilitate electrical device attachment or to facilitate electrical connection and disconnection according to an embodiment of the present invention;

Figure 14 is a top view of a warp knitted fabric structure;

Figure 15 is a top view of fabric-based signal transmission system in which conductive threads are warp knitted into a fabric to form a twisted pair structure according to an embodiment of the present invention;

Figure 16 is a top view of a fabric-based signal transmission system in which conductive threads are warp knitted into a fabric to form a coaxial structure according to an embodiment of the present invention;

Figure 17 is a top view of a fabric-based signal transmission system in
5 which conductive threads are weft knitted into a fabric to form a twisted pair structure according to an embodiment of the present invention;

Figure 18 is a top view of a fabric-based signal transmission system in which conductive threads are weft knitted into a fabric to form a coaxial structure according to an embodiment of the present invention;

10 Figure 19 is a top view of a fabric-based signal transmission system in which a coaxial conductive yarn structure is warp knitted into a fabric according to an embodiment of the present invention;

Figure 20 is a top view of a fabric-based signal transmission system in which a coaxial conductive yarn structure is weft knitted into a fabric according
15 to an embodiment of the present invention;

Figure 21 is a top view of a fabric-based signal transmission system in which a twisted pair conductive yarn structure is warp knitted into a fabric according to an embodiment of the present invention;

Figure 22 is a top view of a fabric-based signal transmission system in
20 which a twisted pair conductive yarn structure is weft knitted into a fabric to form a coaxial structure according to an embodiment of the present invention;

Figure 23 is a top view of a fabric-based signal transmission system in which signal carrying conductive threads are separated by grounded conductors;

Figures 24A and 24B illustrate multi-layered fabric-based signal transmission systems according to embodiments of the present invention;

Figure 25 is a perspective view of an insulated conductive yarn structure surrounded by a braided outer conductor according to an embodiment of the
5 present invention;

Figure 26 is a top view of a fabric-based signal transmission system in which braided coaxial yarn structures are woven parallel to each other in a fabric according to an embodiment of the present invention;

Figure 27 is a top view of a fabric-based signal transmission system in
10 which a braided coaxial yarn is warp knitted into a fabric according to an embodiment of the present invention;

Figure 28 is a top view of a fabric-based signal transmission system in which a braided coaxial yarn is weft knitted into a fabric according to an embodiment of the present invention;

15 Figure 29 is a top view of a fabric-based signal transmission system including a plurality of coaxial conductive yarn structures being braided into a fabric according to an embodiment of the present invention;

Figure 30 is a top view of a fabric-based signal transmission system including a plurality of twisted pair conductive yarns being braided into a fabric
20 according to an embodiment of the present invention;

Figure 31 is a top view of a fabric-based signal transmission system including a plurality of braided coaxial conductive yarn structures being braided into a fabric according to an embodiment of the present invention;

Figure 32 is a top view of a fabric-based signal transmission system including a woven fabric having a plurality of braided conductive yarn structures according to an embodiment of the present invention;

Figure 33 is a top view of a fabric-based signal transmission system
5 including a warp-knitted fabric having a plurality of braided conductive yarn structures according to an embodiment of the present invention; and

Figure 34 is a top view of a fabric-based signal transmission system including a weft-knitted fabric having a plurality of braided conductive yarn structures according to an embodiment of the present invention

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Detailed Description of the Invention

The present invention includes conductive yarn structures for improving signal integrity in fabric-based electrical networks. Figure 1 illustrates an example of one conductive yarn structure suitable for improving signal integrity
15 in fabric-based electrical networks according to an embodiment of the present invention. Referring to Figure 1, a conductive yarn structure **100** comprises a coaxial conductive yarn structure. Coaxial conductive yarn structure **100** includes an inner conductive yarn **102** surrounded by an insulating layer **104** and an outer conductive yarn **106**, which is preferably also surrounded by an
20 insulating layer **108**. Inner conductive yarn **102** includes a plurality of conductive strands being twisted together. The conductive strands may be made of any suitable conductive material, such as such as copper, gold, steel, aluminum, silver, or iron or conductive polymers (inherently conductive

polymeric materials, such as polypyrrole, polyacetylene, polythiophene and polyaniline, doped conductive polymeric materials, carbon black-doped/impregnated polymeric yarns, metal coated polymeric yarns or fibers and conductive yarns of all different kinds). Outer conductive yarn **106** also
5 includes a plurality of strands being twisted together. In one example, outer conductive yarn **106** may be made of silver-coated nylon or any of the above-mentioned conducting materials. Insulating layers **104** and **108** may be made of any suitable insulating material, such as polyvinylchloride; rubber; rubber forming polymers, including polyisoprene, polybutadiene, polychloroprene, and
10 polyisobutylene; polyesters; polyolefins; and polyamides. In one example, insulating layers **104** and **108** may be made of polyvinylchloride.

It is important to note that structures **102** and **106** are yarns, rather than wires. The term "yarn" is defined above and is not intended to include conventional wires. As indicated above, the term "yarn," as used herein, refers
15 to a structure that exhibits sufficient flexibility, conformability, resiliency, bending characteristics, and recovery required for fabric-based circuits to be incorporated in wearable garments. Conventional wires lack one or more of these characteristics, making them unsuitable for incorporation in a fabric. The individual strands forming the yarn may be very fine wires twisted to form the
20 yarn, but the diameter of these fine wires should ideally be less than 20 microns to provide sufficient flexibility and conformability of the yarn or twisted strand structure.

Coaxial conductive yarn structure **100** may be constructed by first forming inner and outer conductive yarns **102** and **106**. These yarns may be formed using conventional yarn twisting techniques. Once the inner and outer conductive yarns are formed, insulating layers **104** and **108** may be applied to either or both yarns. Inner conductive yarn **102** and outer conductive yarn **106** may then be fed into a yarn covering machine or a yarn wrapping machine. The yarn covering or wrapping machine may wind or wrap outer conductive yarn **106** around inner conductive yarn **102**. A yarn covering machine used for wrapping a yarn around an elastomeric core yarn could be used to develop the coaxial yarn structure. In that case, in order to reduce the likelihood of breakage, the wrapping speed of the yarn covering machine is preferably reduced over that used for wrapping elastomeric yarns. The wrapping of conductive yarns **106** around the conductive yarn **102** can also be carried out using a yarn twisting machine (for example, a ring twister) to wrap yarn **106** with insulation **108** around yarn **102** with insulation **104**.

Figure 2 illustrates another example of a conductive yarn structure suitable for improving signal integrity in a fabric-based signal transmission system according to an embodiment of the present invention. Referring to Figure 2, conductive yarn structure **200** comprises a twisted pair conductive yarn structure. Twisted pair conductive yarn structure **200** includes first and second conductive yarns **202** surrounded by insulating layers **204** and being twisted together to form a helical structure. Conductive yarns **202** are preferably made of multiple strands of a conductive material, such as such as

copper, gold, steel, aluminum, silver, iron, any of the alloys from the above mentioned materials, and conductive polymers (inherently conductive polymeric materials, such polypyrrole, polyacetylene, polythiophene and polyaniline, doped conductive polymeric materials, carbon black-doped/impregnated

5 polymeric yarns, metal coated polymeric yarns, or fibers and conductive yarns of all different kinds). As with the coaxial structure described above, the multiple strands are preferably twisted together to form a yarn. Insulating layer **204** may be made of any suitable insulating material, such as polyvinylchloride; rubber; rubber forming polymers, including polyisoprene, polybutadiene,

10 polychloroprene, and polyisobutylene; polyesters; polyolefins; and polyamides.

The strands that form conductive yarns **202** may be twisted together using a conventional yarn twisting machine, as described above. Once conductive yarns **202** have been formed, insulating layers **204** are preferably added to conductive yarns **202**. Conductive yarns **202** are preferably then twisted into a

15 helical structure using a yarn twisting machine.

Figure 3 illustrates an example of a woven electrical network including coaxial conductive yarn structures according to an embodiment of the present invention. In the illustrated example, woven electrical network **300** includes coaxial conductive yarn structures **100**. Coaxial conductive yarn structures **100**

20 are incorporated in woven electrical network **300** and extend in a direction parallel to each other. For example, coaxial conductive yarn structures **100** may be weft or warp yarns or both woven into a fabric.

According to an important aspect of the invention, outer conductors **106** of coaxial conductive yarn structures **100** are preferably connected to ground **302**. In a preferred embodiment of the invention, outer conductors **106** may be welded to a signal ground at a fabric crossover point, for example, as described
5 in commonly-assigned, co-pending U.S. patent application number 10/041,248 filed January 8, 2002, the disclosure of which is incorporated herein by reference in its entirety. Connecting outer conductors **106** to ground blocks electromagnetic fields emanating from inner conductors **102**. This blocking reduces crosstalk between adjacent conductive yarn structures and improves
10 signal integrity. An AC signal source **304** may be connected to one or both of inner conductive yarns **102** of the coaxial conductive yarns structures. The AC signal source may be any suitable signal source, depending on the particular application. A plurality of nonconductive fibers **306** may be included in the fabric along with coaxial conductive yarn structures **100**. In one example,
15 nonconductive fibers **306** comprise nylon yarns.

In operation, AC signal source **304** applies a signal to inner conductive yarn **102**. Electromagnetic fields emanate from inner conductive yarns **102**. However, grounded outer conductive yarns **106** block these fields and thereby prevent crosstalk on adjacent lines.

20 In order to make a woven electrical network, such as that illustrated in Figure 3, coaxial conductive yarn structures **100** and nonconductive fibers **306** may be fed into a loom as warp yarns, weft yarns, or both. In the illustrated example, coaxial conductive yarn structures **100** extend in a direction parallel to

each other in woven electrical network **300**. An example of a loom suitable for weaving coaxial conductive yarn structures **100** into a loom is an Eltex loom with Staubli Jacquard heads.

Figure 4 illustrates yet another example of a woven electrical network including conductive yarn structures designed to reduce crosstalk between adjacent lines and to improve signal integrity. In Figure 4, twisted pair conductive yarn structures **200** are woven into a fabric to form a woven electrical network **400**. For example, twisted pair conductive yarn structures **200** may be woven into the fabric as warp yarns, weft yarns, or both. In the illustrated example, twisted pair conductive yarn structures **200** extend in a direction parallel to each other in woven electrical network **400**. Woven electrical network **400** may be made by feeding twisted pair conductive yarn structures and nonconductive fibers **306** into any suitable loom such as a Jacquard loom, as described above.

In one mode of operation of the twisted pair conductive yarn structures **200** in woven electrical network **400**, one conductor **202** of each twisted pair conductive yarn structure is connected to ground **302**. The other conductor **202** of at least one of the twisted pair conductive yarn structures is connected to an AC signal source **304**. Connections between conductors **202** and ground and signal source **304** may be made using welding, as described in the above-referenced commonly-assigned co-pending U.S. patent application. In operation, when AC signal source **304** applies an AC signal to conductor **202**, the grounded conductors block electromagnetic fields emanating from signal-

carrying conductor **202**. As a result, crosstalk between twisted pair conductive yarn structures **200** is reduced. In another mode of operation of the twisted pair threads, the two conductive threads **202** are oppositely driven by an AC signal source. Driving conductive threads of a twisted pair structure with equal but
5 opposite AC signals results in common mode noise rejection. Either mode of operation is intended to be within the scope of the invention.

Although the examples in Figures 3 and 4 illustrate coaxial and twisted pair conductive yarn structures in separate fabrics, it is understood that these structures can be incorporated into the same fabric. Any suitable combination
10 of coaxial and twisted pair conductive yarn structures is intended to be within the scope of the invention.

Fabric Structures to Improve Signal Integrity

Leno Weave Structures

15 In addition to the coaxial and twisted pair conductive yarn structures described above, the present invention may also include fabric structures in which both coaxial and twisted pair structures can be formed while a fabric is being knitted or woven. Forming coaxial and twisted pair structures as a fabric is being knitted or woven improves manufacturing efficiency in making fabric-
20 based signal transmission systems and facilitates creation of floats for electrical device connection and disconnection and for electrical device attachment.

Figure 5 illustrates an example of a fabric-based signal transmission system **500** in which twisted pair structures can be formed while the fabric is

being woven according to an embodiment of the present invention. Referring to Figure 5, a plurality of warp threads **502** and **504** are twisted around consecutive weft threads **506**. This type of configuration is referred to in the textiles industry as a leno weave. A leno weave involves pair-wise crossing of adjacent warp threads in a woven fabric. A leno weave is a form of plain weave in which adjacent warp threads are twisted around consecutive weft threads to form a spiral pair, effectively locking each weft in place. According to the present invention, warp threads **502** and **504** are preferably insulated conductive threads or yarns. Leno weaving conductive warp threads in the manner shown in Figure 5 produces twisted pair conductive yarn structures, which exhibit common mode noise rejection when threads **502** and **504** are oppositely driven by an AC signal source. In another mode of operation of the fabric-based signal transmission system **500** containing leno-woven twisted pair conductive yarn structures, one conductor **502** of each leno-woven twisted pair conductive yarn structure is connected to ground. The other conductor **504** of at least one of the leno-woven twisted pair conductive yarn structures is connected to an AC signal source.

According to an important aspect of the invention, the twisted pair yarn structures formed by threads **502** and **504** can be accomplished during the weaving process by the use of leno headles, which allows control of individual warp yarns. In Figure 5, warp threads **502** and **504** cross nonconductive threads **506** on alternating sides. However, the present invention is not limited to forming twisted pair conductive yarn structures using only this type of leno

weave. Any suitable leno weave in which twisted pair or coaxial structures can be formed while a fabric is being woven is intended to be within the scope of the invention.

Figure 6 illustrates a fabric-based signal transmission system **600** in which twisted pair structures are formed using a bottom doup leno weave. In a bottom doup leno weave, the doup warp thread goes over consecutive weft threads and crosses below the adjacent warp thread between two weft threads. In Figure 6, threads **602** and **604** are preferably insulated conductors. Threads **606** may be conductive or nonconductive. If threads **606** are conductive, they are preferably insulated. In the configuration illustrated in Figure 6, thread **604** is the doup warp thread that passes over consecutive weft threads **606** and below warp thread **602** between adjacent weft threads **606**. By using a bottom doup leno weave, the twisted pair structures can be formed by conductors **602** and **604** at the same time conductors **602** and **604** are being woven into a fabric. As stated above, this increases the efficiency with which fabric-based signal transmission systems with improved signal integrity characteristics can be manufactured.

The present invention is not limited to forming twisted pair and coaxial structures using a bottom doup leno weave. In an alternate embodiment of the invention, the twisted pair structures can be formed using a top doup leno weave. In case of top doups, the doup warp thread goes below consecutive weft threads and crosses above the adjacent warp thread (the ground threads) in between two weft threads. Twisted pair and coaxial structures of the present

invention can also be formed with the doup thread going above and below the consecutive weft threads but always being above the adjacent warp threads in order to form a spiral pair, as illustrated in Figure 5. In addition, the fabric-based signal transmission systems of the present invention that are made
5 using a leno weave can be combined with other weaving techniques to form a wearable garment with one or more electrical circuits.

It should be noted that in the twisted pair structures described herein, one conductor may be connected to an AC or DC signal source and the other conductor may be grounded, similar to a coaxial signal transmission system in
10 which the inner conductor carries a signal and the outer conductor is grounded. In an alternate mode of operation, the conductors in a twisted pair structure may be oppositely driven by an AC signal source. Either mode of operation is intended to be within the scope of the invention.

In the leno-woven twisted pair structures described herein, either or both
15 of the conductive threads that form the twisted pair structure may be insulated conductive yarns, as illustrated in Figure 2. Figure 7 illustrates this concept. In Figure 7, a fabric-based signal transmission system **700** includes insulated conductive threads **702** and **704** being leno woven into a fabric with weft threads **706**, which may be conductive (preferably insulated conductive threads
20 especially if either one of threads **702** or **704** is not insulated) or nonconductive. Each thread **702** and **704** may include a plurality of inner conductive strands being twisted together to form a conductive yarn **202** and may be coated with an outer insulating layer **204**.

As stated above, the leno weaving may be combined with other types of weaving techniques to form a garment incorporating one or more electrical circuits. Figure 8 illustrates a fabric-based signal transmission system **800** where twisted pair structures are leno woven in a fabric, and the fabric includes
5 a plain woven portion. In Figure 8, threads **802** and **804** are preferably insulated conductive threads, as described above. Threads **810** and **812** may be conductive or nonconductive. In the illustrated example, threads **802** and **804** are leno-woven into the fabric and form a twisted pair structure. Similarly, threads **806** and **808** are leno-woven into the fabric to form an additional
10 twisted pair structure. However, threads **810** are plain woven into the fabric. Such a combination weave may be formed on a Jacquard loom where threads are individually addressable.

As stated above, in one mode of operation, one insulated conductive thread forming the spiral pair of a leno weave may be connected to ground and
15 the other conductive thread may be connected to a signal source, such as an AC signal source. Figure 9 illustrates this mode of operation. In Figure 9, conductive threads **804** and **808** are connected to AC signal supplies **900** and conductive threads **802** and **806** are connected to ground **902**. In this arrangement, AC signal crosstalk between conductive threads **804** and **808** is
20 significantly reduced. As a result, using this configuration, the density of fabric-based signal transmission systems can be increased, which increases the functionality that can be provided by fabric-based electrical circuits. In addition, because the twisted pair structure is formed using a leno weave, rather than

separately weaving the twisted pair structure and then weaving the twisted pair structure into the fabric, manufacturing time is reduced.

Another advantage of forming twisted pair structures while weaving a fabric is that the twisting of the conductive threads can be controlled to form floats in regions of the fabric to facilitate electrical connection and disconnection and also electrical device attachment. Figure 10 illustrates an example of a fabric-based signal transmission system **1000** including floats according to an embodiment of the present invention. In Figure 10, threads **1002-1008** are preferably insulated conductive threads, as described above.

Threads **1010** and **1012** may be conductive or nonconductive. Threads **1006** and **1008** are leno-woven into the fabric to form a twisted pair structure. Similarly, threads **1002** and **1004** are leno-woven into the fabric to form an additional twisted pair structure. Threads **1002** and **1006** each include a floating region **1014** to facilitate electrical connection and disconnection and also to facilitate electrical device attachment. Threads **1004** and **1008** each include a plain-woven region **1016**, rather than a floating region, so that the threads can be separately identified when making electrical connections and disconnections. Threads **1004** and **1008** may also each include a floating region **1014** to facilitate electrical connection and disconnection and also to facilitate electrical device attachment.

As mentioned above, electrical connection in a fabric-based signal transmission system may be performed by welding conductive threads at crossover points, which may correspond to floats. Electrical disconnection may

be effected by cutting conductive threads at the floats. Figure 11 illustrates a signal transmission system **1100** including a crossover point at which electrical connection or disconnection can be made. In Figure 11, threads **1102-1108** are assumed to be insulated conductors. Threads **1110** may be conductive or nonconductive. Conductive threads **1102** and **1104** may be a pre-formed twisted pair structure. In contrast, conductive threads **1106** and **1108** are a twisted pair structure that was created while conductive threads **1110** were being leno woven into the fabric. It can be seen that conductive threads **1102** and **1104** intersect conductive threads **1106** and **1108** at a crossover point **1112**. By selectively dissolving the insulating layers on the conductive threads and welding conductors together, electrical connection between orthogonal conductive threads can be achieved. In addition, it may be desirable to weld all of the crossover points in a fabric. In such an example, electrical circuits can be created by selectively disconnecting by cutting floats on appropriate sides of the crossover points.

In addition to producing signal transmission systems with twisted pair structures simultaneously with weaving conductive threads into a fabric, coaxial structures can also be produced while weaving conductive threads into a fabric. Figure 12 illustrates an example of a coaxial structure that can be produced while weaving conductive threads into a fabric according to an embodiment of the present invention. In Figure 12, a fabric-based signal transmission system **1200** includes insulated conductive threads **1202**, **1204**, and **1206** and threads **1208**, which may be conductive or nonconductive. Conductive threads **1202**,

1204, and **1206** are leno-woven into the fabric to form a coaxial structure. This structure can be formed at the time threads **1202**, **1204**, and **1206** are being woven into the fabric by using a Jacquard loom equipped with leno headles. Because the coaxial structure can be formed at the time the fabric is created,
5 the time and cost required to manufacture garments including coaxial structures is reduced. In addition, as described above, forming the coaxial structures at weaving time facilitates production of floating regions for electrical connection and disconnection and also electrical device attachment.

In operation, conductor **1206** may be connected to an AC signal source
10 and conductors **1202** and **1204** may be connected to ground. Connecting conductors **1202** and **1204** to ground reduces the likelihood that external electromagnetic interference will affect the signal on conductor **1206**. Connecting conductors **1202** and **1204** to ground also reduces the likelihood that the signal on conductor **1206** will adversely affect signals on other
15 conductors. As a result, signal conductors can be placed close to each other in a fabric and component density can be increased.

As with the twisted pair structures described above, floats can be formed in coaxial structures to facilitate electrical connection and disconnection. Figure 13 illustrates an example of a coaxial structure with
20 floats according to an embodiment of the present invention. In Figure 13, a fabric-based signal transmission system **1300** includes insulated conductive threads **1302**, **1304**, and **1306**, which are leno woven in the fabric to form a coaxial structure. Threads **1308** are woven in the fabric in the weft direction

and may be conductive or nonconductive. In region PQ, the twisting of threads **1302**, **1304**, and **1306** is preferably stopped so that the threads run parallel to each other to form floats. These parallel floats may be used for selective electrical connection and disconnection with orthogonal threads at crossover points or for electrical device attachment, in the manner described above.

Knitted Structures

In addition to coaxial and twisted pair structures formed simultaneously with weaving a fabric, the present invention also includes coaxial and twisted pair structures formed simultaneously with knitting a fabric. Such structures can be produced on knitting machines using any of the knitting processes (for example, warp knitting or weft knitting). In warp knitting, lateral translation of any thread is possible and this can be used for the formation of twisted pair and coaxial structures on the knitting machine itself. Warp knitting consists of threads passing up the length of the fabric, with each thread intersecting with the thread on each side as shown in Figure 14. In Figure 14, a warp-knitted fabric **1400** includes warp knitted threads **1402**. One of the threads **1402** is highlighted to illustrate its interconnection with neighboring threads. This fabric has the same appearance on each side, does not ladder, and is difficult to unravel.

Figure 15 illustrates an example of a twisted pair structure formed using warp knitting according to an embodiment of the present invention. In Figure 15, a fabric-based signal transmission system **1500** includes warp knitted

threads **1502**, **1504**, and **1506**. Threads **1502** and **1504** may be insulated
conductive threads. Threads **1506** may be conductive or nonconductive.
Threads **1502** and **1504** are warp knitted to each other to form a twisted pair
structure. In operation, thread **1502** may be connected to a signal source and
5 thread **1504** may be connected to ground or vice-versa. In another mode of
operation, threads **1502** and **1504** may be oppositely driven by an AC signal
source. Connecting one of the conductive threads to ground and the other
thread to a signal source improves signal integrity in a fabric-based electrical
network because the ground conductor blocks electromagnetic field lines
10 emanating from signal conductors. Driving conductive threads of a twisted pair
structure with equal but opposite AC signals results in common mode noise
rejection. Either mode of operation is intended to be within the scope of the
invention.

In addition to twisted pair structures, coaxial structures can also be
15 formed while the threads that form the coaxial structures are being warp knitted
into a fabric. Figure 16 illustrates an example of a warp knitted fabric-based
signal transmission system including a coaxial structure according to an
embodiment of the present invention. Referring to Figure 16, a warp-knitted
fabric-based signal transmission system **1600** includes insulated conductive
20 threads **1602**, **1604**, and **1606** being warp knitted to each other to form a
coaxial structure and threads **1608**, which may be conductive or
nonconductive. In operation, thread **1602** may be connected to an AC signal
source and threads **1604** and **1606** may be connected to ground. Because

grounded threads **1604** and **1606** surround conductive thread **1602**, electric fields produced by other conductors will have a reduced effect on signals on thread **1602**. Similarly, electric fields produced by thread **1602** will have a reduced effect on signals on other signal carrying conductors. As a result, signal-carrying conductors can be placed closer to each other in a fabric-based signal transmission system, increasing the potential device density and thereby increasing the functionality of garments incorporating such devices.

Weft Knitting can also be used to form twisted structures. Figure 17 illustrates an example of a twisted pair structure formed using weft knitting according to an embodiment of the present invention. Referring to Figure 17, a weft-knitted fabric-based signal transmission system **1700** includes insulated conductive threads **1702** and **1704** being weft knitted to each other to form a twisted pair structure. Conductive threads **1702** and **1704** are also weft-knitted to threads **1706**, which may be conductive or nonconductive. The twisted pair structure formed by weft knitted threads **1702** and **1704** may be formed on a knitting machine at the time the fabric is created – thus decreasing the time to incorporate such structures into a fabric over techniques that require the twisted pair structure to be formed in advance of incorporating the structure into a fabric.

In one exemplary mode of operation, thread **1702** may be connected to a signal source and thread **1704** may be connected to ground, or vice-versa. In this mode of operation, thread **1704** blocks electromagnetic fields emanating from signal carrying thread **1702** from adversely affecting signals on other

conductors. In addition, ground thread **1704** reduces the effect of electromagnetic fields from other conductors on the signal on signal carrying thread **1702**. In an alternate mode of operation, threads **1702** and **1704** may be oppositely driven by and AC signal source. In this mode of operation, noise
5 common to both threads (common-mode noise) may be rejected.

In addition to being used to form twisted pair structures, weft knitting can also be used to form coaxial structures. Figure 18 illustrates an example of a coaxial structure formed using weft knitting according to an embodiment of the present invention. In Figure 18, a weft-knitted fabric-based signal transmission
10 system **1800** includes insulated conductive threads **1802**, **1804**, and **1806** being weft knitted to each other to form a coaxial structure. Conductive threads **1802**, **1804**, and **1806** are also weft knitted to threads **1808** to form a fabric. Threads **1808** may be conductive or nonconductive. Because the coaxial structures formed by threads **1802**, **1804**, and **1806**, can be formed at the time
15 that the fabric is being knitted, the time required to produce garments including these structures is reduced.

In operation, thread **1802** may be connected to a signal source, and threads **1804** and **1806** may be connected to ground. Because grounded threads **1804** and **1806** block electromagnetic fields, signals on other
20 conductors near thread **1802** will have a reduced effect on the signal on the signal on thread **1802** and vice-versa. As a result, signal-carrying conductors can be placed closer together in a garment, device density can be increased, and the functionality of fabric-based electrical circuits can also be increased.

While Figures 3 and 4 above illustrate weaving of the coaxial and twisted pair structures illustrated in Figures 1 and 2 into a fabric, the coaxial and twisted pair conductive yarn structures illustrated in Figures 1 and 2 can be knitted into a fabric. Figure 19 illustrates exemplary warp knitting of coaxial conductive yarn structure **100** into a fabric. In Figure 19, a fabric-based signal transmission system **1900** includes a conductive yarn **1902** and yarns **1904**, which may be conductive or nonconductive. In the illustrated example, conductive yarn **1902** may be similar in structure to coaxial conductive yarn structure **100**. That is, yarn **1902** may include an inner conductor **102** having a plurality of conductive strands being twisted together, an insulating layer **104** surrounding the conductive strands, and an insulated outer conductor **106**. In operation, conductor **102** may be connected to a signal source and conductor **106** may be connected to ground, resulting in improved signal integrity.

In addition to warp knitting, coaxial conductive yarn structure **100** can also be weft-knitted into a fabric. Figure 20 illustrates an example in which coaxial conductive yarn structure **100** is weft-knitted in a fabric. In Figure 20, a fabric-based signal transmission system **2000** includes a conductive yarn **2002** being weft knitted into a fabric with a plurality of other yarns **2004**. In this example, conductive yarn **2002** may be similar in structure to coaxial conductive yarn structure **100** described above. In operation, conductor **102** may be connected to a signal source and conductor **106** may be connected to ground, resulting in improved signal integrity in weft-knitted fabric-based circuits.

As stated above, twisted pair conductive yarn structure **200** illustrated in Figure 2 can also be knitted into a fabric. Figure 21 illustrates an example of a fabric-based signal transmission system in which twisted pair conductive yarn structure **200** is weft knitted in a fabric. In Figure 21, a fabric-based signal transmission system **2100** may include a conductive yarn **2102** being warp knitted in a fabric with a plurality of yarns **2106**. In the illustrated example, conductive yarn **2102** is similar in structure to twisted pair conductive yarn structure **200** illustrated in Figure 2. That is, conductive yarn **2102** may include first and second conductive yarns **202** being twisted together to form a helical structure. Each yarn **202** is preferably surrounded by an insulating layer **204** to prevent short-circuiting. In operation, one conductor **202** may be connected to a signal source, and the other conductor **202** may be connected to ground. Alternatively, conductors **202** may be oppositely driven to reject common mode noise.

In addition to warp knitting, twisted pair conductive yarn structure **200** can be weft-knitted into a fabric. Figure 22 illustrates a fabric-based signal transmission system in which twisted pair conductive yarn structure **200** is weft knitted in a fabric. In Figure 22, a fabric-based signal transmission system includes a conductive yarn **2202** being weft knitted in a fabric with a plurality of additional yarns **2204**. Conductive yarn **2202** may be similar in structure to twisted pair conductive yarn structure **200** described above. Yarns **2204** may be conductive or nonconductive. In operation, the conductors of yarn structure **2202** may be oppositely driven. Alternatively, one conductor of yarn **2200** may

be connected to a signal source and the other conductor may be grounded, as described above.

In the examples illustrated in Figures 3 and 4, coaxial and twisted pair conductive yarn structures **100** and **200** are plain woven into a fabric.

5 However, the present invention is not limited to plain weaving these structures into a fabric and other weaves, such as Twill, Basket, Satin, or Sateen could be used. In an alternate embodiment of the invention, these structures may be leno-woven into a fabric with other similar or different yarn structures to form additional coaxial or twisted pair structures and further improve signal integrity.

10 Similarly, in the examples illustrated in Figures 19-22, single coaxial and twisted pair yarn-structures **100** and **200** are warp or weft knitted into a fabric. However, the present invention is not limited to knitting single structures **100** or **200** into a fabric. In an alternate embodiment of the invention, multiple coaxial or twisted pair structures may be knitted together in a fabric to form additional
15 coaxial and twisted pair structures as the fabric is being knitted.

Structures Involving Placement of Ground Lines and Planes

In a fabric-based circuit board, it is preferable that signal lines be surrounded by ground lines - one on each of its sides and running parallel to it.

20 Figure 23 illustrated an example of a fabric-based signal transmission system where the signal carrying threads are surrounded by ground threads according to an embodiment of the present invention. Referring to Figure 23, a fabric-based signal transmission system **2300** includes an insulated conductive

thread **2302** surrounded on both sides by insulated conductive threads **2304**. Similarly, insulated conductive thread **2308** is surrounded on both sides by conductive threads **2304**. Conductive threads **2302** and **2308** may be signal-carrying conductors and conductive threads **2304** may be connected to ground.

- 5 Because conductive threads **2304** are connected to ground, crosstalk between conductive thread **2302** and neighboring conductive thread **2308** is reduced. The remaining threads **2306** illustrated in Figure 23 are nonconductive.

- In Figure 23, conductive thread **2302** is surrounded on two sides by grounded conductors **2304** in a two-dimensional fabric-based circuit.
- 10 Transmission line system **2300** may be similar to the structure of coplanar waveguides with signal conductor **2302** surrounded by grounded conductors **2304**. That is, grounded conductive threads **2304** can also be multiple non-insulated parallel conducting threads in direct contact with each other to form wide grounded conducting structures surrounding signal carrying conducting
- 15 threads **2302** as in a coplanar waveguide like structure. In a three-dimensional fabric-based circuit, conductive thread **2302** may be surrounded on four sides by grounded conducting elements – from above, below, and from both sides in the plane in which conductive thread **2302** is located.

- The methods and systems for improving signal integrity in fabric-based
- 20 signal transmission systems may be used to form single or multi-layered electrical circuits. Figures 24A and 24B illustrate examples of multi-layered fabric-based circuits in which the fabric-based signal transmission systems of the present invention may be utilized. In Figures 24A and 24B, a multi-layered

signal transmission system **2400** includes a plurality of layers for forming a woven electrical network. These layers can be different fabrics stacked together (with or without a stitch) or could be different layers of a single multilayered fabric structure developed on a loom. In the illustrated example,

5 these layers include a conductive layer **2402**, an insulating layer **2404**, a second conductive layer **2406**, a second insulating layer **2408**, and a third conductive layer **2410**. Conductive layers **2402** and **2410** may be signal-carrying layers similar in structure to the fabric-based signal transmission system illustrated in Figure 23. Insulating layers **2404** and **2408** may include a

10 plurality of nonconductive threads woven or knitted together to form a barrier between adjacent conductive layers. Conductive layer **2406** may be made entirely of conductive threads to form an electromagnetic shield between conductive layers **2402** and **2410**.

In Figure 24B, it can be seen that in operation, layers **2402-2410** are

15 located on top of each other, resulting in an increased chance of crosstalk between layers. However, because layer **2406** is preferably grounded, inter-layer crosstalk is reduced. Using a ground plane can also reduce simultaneous switching noise (SSN). The multilayered fabric structures with signal carrying layers and ground plane layers are similar to some transmission line structures

20 in conventional circuit boards and integrated circuits, such as but not limited to microstrip lines and striplines.

5 Braided and Other Coaxial Yarn Structures and Fabric Woven or Knitted
from such Structures

Although the examples described above relate primarily to wrapped or twisted thread or yarn structures, the present invention is not limited to such structures. In an alternate embodiment of the invention, conductive yarn structures may be braided. Figure 25 illustrates an example of a coaxial conductive yarn structure including a braided outer conductor according to an embodiment of the present invention. In Figure 25, a coaxial conductive yarn structure includes an inner conductor **2502** including a plurality of strands being twisted together, an insulating layer **2504**, and a braided outer conductor a braided outer conductor **2506**. Examples of conductive strand material suitable for use with the present invention include copper, steel, gold, aluminum, silver, iron, any of the alloys from the above mentioned materials, and conductive polymers (inherently conductive polymeric materials, such as polypyrrole, polyacetylene, polythiophene and polyaniline, doped conductive polymeric materials, carbon black-doped/impregnated polymeric yarns, metal coated polymeric yarns or fibers and conductive yarns of all different kinds). Insulating layer may be made up of materials, such as polyvinylchloride, rubber, rubber

forming polymers, including polyisoprene, polybutadiene, polychloroprene, polyisobutylene, polyesters, polyolefins, and polyamides.

Braided coaxial conductive yarn structures **2500** can be woven into a fabric to form a fabric-based signal transmission system. Figure 26 illustrates an example of a fabric-based signal transmission system including braided coaxial conductive yarn structures according to an embodiment of the present invention. Referring to Figure 26, a fabric-based signal transmission system **2600** includes braided coaxial conductive yarn structures **2500** woven into a fabric with yarns **2602**. Yarns **2602** may be or nonconductive. If yarns **2602** are conductive, they are preferably insulated. Inner conductive yarn **2502** of one of conductive yarn structures **2500** is connected to a signal source **2604**. The outer braids of structures **2500** are preferably connected to ground **2606**. Because the outer braids of structures **2500** are grounded, crosstalk between adjacent structures **2500** is reduced. More particularly, when an AC signal is applied to inner conductive yarn **2502** of one or both of coaxial conductive yarn structures **2500**, outer braids **2506** of braided coaxial conductive yarn structures **2500** block electromagnetic fields emanating from the inner conductive yarn **2502** connected to signal source **2604**.

A braided coaxial conductive yarn structure can be knitted into a fabric to form a fabric-based signal transmission system with improved signal integrity characteristics. Figure 27 illustrates a fabric-based signal transmission system in which a braided coaxial conductive yarn structure is knitted into a fabric according to an embodiment of the present invention. In Figure 27, braided

coaxial conductive yarn structure **2500** is warp knitted into a fabric with other yarns **2702**, which are preferably nonconductive. As with the embodiment illustrated in Figure 26, the braided outer conductor of yarn **2500** is preferably grounded to improve signal integrity for the inner conductor. Because the
5 braided outer conductor is grounded, yarn structures, such as structure **2500** can be placed close together in a fabric without adversely affecting each other.

In addition to warp knitting, braided coaxial conductive yarn structure **2500** may also be weft knitted into a fabric. Figure 28 illustrates an example of a braided coaxial conductive yarn structure being weft knitted in a fabric. In
10 particular, a fabric-based signal transmission system **2800** includes braided coaxial conductive yarn structure **2500** being weft knitted with other yarns **2802** in a fabric. Yarns **2802** are preferably nonconductive. In this configuration, the outer conductor of yarn structure **2500** is preferably connected to ground , and the inner conductor is preferably connected to a signal source. Because the
15 outer conductor is grounded, electromagnetic fields have a reduced effect on the signal on the inner conductor. In addition, the signal on the inner conductor of braided conductive yarn structure **2502** will have a reduced effect on other conductors. As a result, braided coaxial conductive yarn structures can be placed closer together, and fabric-based circuit density is increased.

20 Although in the examples illustrated above, the outer conductor in coaxial conductive yarn structures is either wrapped or braided onto the insulating layer the surrounds the inner conductor, the present invention is not limited to such an embodiment. In an alternate embodiment, an outer

conductive layer may be coated or sputtered with a conductive layer using a conductive material that adheres on to the insulation around the first conductor) to form a coaxial yarn. This structure can also be woven or knitted to form fabric-based circuits with reduced crosstalk noise.

5 In the examples set forth above, conductive yarn structures are described as containing metallic fibers being twisted together to form a single conductor with an insulating layer surrounding the conductor and a second conductor surrounding the insulating layer. In an alternate embodiment of the invention, a conductive yarn structure may include a core of coaxial
10 monofilament yarn/fiber produced by fiber spinning of a structure having a conductive material as the core (i.e., made from inherently conductive polymeric materials, such as polypyrrole, polyacetylene, polythiophene and polyaniline, doped conductive polymeric materials, carbon black-
doped/impregnated polymeric material, polymeric material containing metal
15 particles and any other kind of spinnable conducting material), an insulating material surrounding the core, and a conductive material covering the insulation. This yarn structure can also be woven or knitted to form fabric-based circuits with reduced crosstalk noise.

20 Braided Yarn Structures Developed from Coaxial and Twisted Pair Yarn Structures and Fabric Woven or Knitted from Such Structures

Braided conductive yarn structures can be developed from wrapped coaxial conductive yarn structures described above. Figure 29 illustrates braiding of coaxial yarn structures **100** into a single braided conductive yarn. In

Figure 29, a braided conductive yarn structure **2900** includes wrapped coaxial conductive yarns **100**. Different electronic devices, such as sensors, microphones, and integrated circuits may be connected to the inner conductor **102** of the different coaxial yarns **100** in this braided yarn structure **2900**. Outer
5 conductors **106** of coaxial conductive yarn structures **100** may be connected to ground.

Braided conductive yarn structures can also be developed from twisted pair conductive yarn structures described above. Figure 30 illustrates braiding of twisted pair yarn structures **200** into a single braided conductive yarn. In
10 Figure 30, a braided conductive yarn structure **3000** includes twisted pair conductive yarn structures **200**. Different electronic devices, such as sensors, microphones, and integrated circuits can be connected to one of the two conductive yarns **202** of the different twisted pair conductive yarn structures **200** in braided yarn structure **3000**. The other conductive yarn **202** of twisted
15 pair yarn structures **200** may be connected to ground.

Braided conductive yarn structures can be also developed from braided coaxial conductive yarn structures described above. Figure 31 illustrates braiding of braided coaxial yarn structures **2500** into a single braided conductive yarn. In Figure 31, a braided conductive yarn structure **3100**
20 includes braided coaxial conductive yarns **2500**. Different electronic devices, such as sensors, microphones, and integrated circuits, can be connected the inner conductor **2502** of the different coaxial yarns **2500** in this braided yarn

structure **3100**. Braided outer conductors **2506** of the coaxial yarns **2500** can be connected to ground.

Conductive braided yarn structures **2900**, **3000**, and **3100** can be developed on a standard braided yarn manufacture machine. The advantage of using braided conductive yarn structures **2900**, **3000**, and **3100** is that they allow a large number of conductive yarns to be incorporated into one braided yarn structure. Thus, a very high density of coaxial and twisted pair yarns in one conductive braided yarn structure can be achieved. These conductive braided yarn structures can be integrated into a fabric (by weaving or knitting them into a fabric) thereby increasing the density of coaxial and twisted pair threads in the fabric.

Another advantage of conductive braided yarn structures **2900**, **3000**, or **3100** is that small-sized electronic devices, such as sensors, microphones, and integrated circuits, can be connected to the coaxial or twisted pair conductors of the conductive braided yarn in a manner such that they are hidden and protected in the core of the braided structures **2900**, **3000**, or **3100**. Incorporating electronic devices in the core of braided yarn structures **2900**, **3000**, or **3100** may be possible when the braided conductive yarn structure has a hollow core and the electronic devices are smaller than the hollow region in the core of the braided yarn structures **2900**, **3000**, or **3100**. Incorporating electronic devices within the core of braided yarn structures **2900**, **3000**, or **3100** makes the electronic devices invisible on the surface of the fabric into which braided yarns **2900**, **3000**, or **3100** are integrated. Moreover, the

electronic devices can first be attached to the twisted pair or coaxial yarns of the conductive braided yarn structures **2900**, **3000**, or **3100** and then integrate these structures into a fabric by weaving and knitting.

Braided conductive yarn structures **2900**, **3000** or **3100** can be woven
5 into a fabric to form a fabric-based signal transmission system. Figure 32 illustrates an example of a fabric-based signal transmission system including braided conductive yarn structures according to an embodiment of the present invention. Referring to Figure 32, a fabric-based signal transmission system **3200** includes conductive braided yarn structures **2900**, **3000** or **3100** woven
10 into a fabric with yarns **3204**. Yarns **3204** may be conductive (with an insulating layer around the conductive yarns) or nonconductive.

Braided conductive yarn structures **2900**, **3000** or **3100** can also be warp knitted into a fabric to form a fabric-based signal transmission system. Figure 33 illustrates an example of a fabric-based signal transmission system
15 including braided conductive yarn structures according to an embodiment of the present invention. Referring to Figure 33, a fabric-based signal transmission system **3300** includes conductive braided yarn structures **2900** or **3000** or **3100** warp knitted into a fabric with yarns **3304**. Yarns **3304** may be conductive (with an insulating layer around the conductive yarns) or nonconductive.

20 Braided conductive yarn structures **2900**, **3000** or **3100** can also be weft knitted into a fabric to form a fabric-based signal transmission system. Figure 34 illustrates an example of a fabric-based signal transmission system including braided conductive yarn structures according to an embodiment of the

present invention. Referring to Figure 34, a fabric-based signal transmission system 3400 includes conductive braided yarn structures **2900**, **3000** or **3100** weft knitted into a fabric with yarns **3404**. Yarns **3404** may be conductive (with an insulating layer around the conductive yarns) or nonconductive.

5

Experimental Results

In experiments using yarn structures of the present invention, the crosstalk on adjacent lines using yarn structures according to the present invention is significantly reduced over nongrounded conductive yarn structures.

10 For example, the reduction in crosstalk noise appearing on a quiet line in one of the experiments was reduced by a factor of nearly five. Because the present invention greatly reduces crosstalk in woven and other fabric-based networks, conductive yarn structures can be spaced more closely to each other in fabric-based networks. Consequently, component density can be increased without
15 increasing circuit board area.

Thus, the present invention includes conductive yarn, thread, and fabric structures with improved signal integrity characteristics. In addition, the present invention includes methods for making yarn and thread structures while these structures are being knitted or woven into a fabric. Such methods decrease the
20 time required to produce fabric-based electric circuits and facilitate creation of regions in the threads for electrical device interconnection and disconnection.

It will be understood that various details of the invention may be changed without departing from the scope of the invention. Furthermore, the

foregoing description is for the purpose of illustration only, and not for the purpose of limitation—the invention being defined by the claims.